

I. IN THE CLAIMS

1-18. (Canceled).

19. (Currently amended) A method for determining coordinates of a workpiece (9) fastened to a movable structure, said movable structure having a reference object fastened thereto, comprising:

measuring, using a first coordinate measuring device (3), first coordinates of said workpiece (9) in a first coordinate system;

measuring, using said first coordinate measuring device (3), first coordinates of said reference object;

measuring, using a second coordinate measuring device (5), second coordinates of said workpiece (9) in a second coordinate system;

measuring, using said second coordinate measuring device (5), second coordinates of said reference object in said second coordinate system; and

determining, using at least said first coordinates of said reference object and said second coordinates of said reference object, a set of coordinates for said workpiece (9) including coordinate values derived from said first coordinates of said workpiece (9) and said second coordinates of said workpiece (9).

20. (Previously presented) The method of claim 19 wherein said first coordinate system is fixed relative to said workpiece (9).

21. (Previously presented) The method of claim 19 wherein said movable structure is a pallet.

22. (Previously presented) The method of claim 19, wherein the method comprises moving said movable structure from a first coordinate measuring device location after measuring using said first coordinate measuring device to a second coordinate measuring device location and before measuring using said second coordinate measuring device.

23. (Canceled)

24. (Previously presented) The method of claim 19 wherein said first coordinate measuring device (3) measures a different property of said workpiece than said second coordinate measuring device (5).

25. (Previously presented) The method of claim 19 wherein said first coordinate measuring device is designed to measure coordinates of points on a surface.

26. (Previously presented) The method of claim 19 wherein said second coordinate measuring device is designed to transirradiate said workpiece with radiation and derive coordinates for said work piece from measurements of said radiation.

27. (Previously presented) The method of claim 19 wherein said measuring, using a second coordinate measuring device (5), second coordinates of said workpiece (9) in a second coordinate system comprises measuring in a spatial region wherein an edge or material interface of at least one of said workpiece and said reference object exists.

28. (Previously presented) The method of claim 19 wherein said steps of:  
measuring, using said first coordinate measuring device (3), first coordinates of said workpiece (9) in said first coordinate system;

measuring, using said first coordinate measuring device (3), first coordinates of said reference object;

measuring, using said second coordinate measuring device (5), second coordinates of said workpiece (9) in a second coordinate system; and

measuring, using said second coordinate measuring device (5), second coordinates of said reference object in said second coordinate system;

occur during at least one of producing and machining said workpiece.

29. (Currently amended) The method of claim 19 further comprising:  
measuring with a temperature sensor a first temperature of at least one of said workpiece and said movable structure during said measuring, using said first coordinate measuring device (3), first coordinates of said workpiece (9) in said first coordinate system; and  
—measuring a second temperature of at least one of said workpiece and said movable structure during said measuring, using said second coordinate measuring device (5), second

coordinates of said workpiece (9) in a second coordinate system.

30. (Currently amended) The method of claim 29 19 wherein said determining further comprises calculating using coefficient of thermal expansion of materials of at least one of said movable structure and said workpiece ~~to determine said set of coordinates for said workpiece.~~

31. (Currently amended) The method of claim 29 ~~wherein said measuring a first temperature comprises measuring using a~~ further comprising integrating a temperature sensor in ~~connected to~~ said movable structure.

32. (Previously presented) The method of claim 19 further comprises sequentially moving additional workpieces into positions for measuring using said first coordinate measuring device and said second coordinate measuring device.

33. (Currently amended) An apparatus for determining coordinates of a workpiece (9) fastened to a movable structure, said movable structure having a reference object fastened thereto, comprising:

a first coordinate measuring device (3) for measuring first coordinates of said workpiece (9) in a first coordinate system;

said first coordinate measuring device (3), also for measuring first coordinates of said reference object;

a second coordinate measuring device (5), for measuring second coordinates of said workpiece (9) in a second coordinate system;

said second coordinate measuring device (5), also for measuring second coordinates of said reference object in said second coordinate system; and

a device for determining, using at least said first coordinates of said reference object and said second coordinates of said reference object, a set of coordinates for said workpiece (9) including coordinate values derived from said first coordinates of said workpiece (9) and said second coordinates of said workpiece (9).

34. (Previously presented) The apparatus of claim 33 wherein said movable structure is a pallet.

35. (Currently amended) A method of making an apparatus for determining coordinates of a workpiece (9) fastened to a movable structure, said movable structure having a reference object fastened thereto, comprising:

providing a first coordinate measuring device (3) for measuring first coordinates of said workpiece (9) in a first coordinate system;

said first coordinate measuring device (3), also for measuring first coordinates of said reference object;

providing a second coordinate measuring device (5), for measuring second coordinates of said workpiece (9) in a second coordinate system;

said second coordinate measuring device (5), also for measuring second coordinates of said reference object in said second coordinate system; and

providing a device for determining, using at least said first coordinates of said reference object and said second coordinates of said reference object, a set of coordinates for said workpiece (9) including coordinate values derived from said first coordinates of said workpiece (9) and said second coordinates of said workpiece (9).

36. (Currently amended) The method of claim ~~34~~ 35 wherein said movable structure is a pallet.

37. (New) The method of claim 19 wherein said determining also comprises measuring, using a temperature sensor, at least one temperature value.

38. (New) The method of claim 37 wherein said temperature sensor is integrated with said movable structure.

39. (New) The method of claim 38 further comprising calculating at least one of position and scaling of said workpiece and said movable structure as a function of said at least one temperature value and at least one thermal coefficient of one material forming at least one of said workpiece and said movable structure.